

Date: Wednesday, 4/25/2007 2:38:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI UTILITY BASKET LH/RH 350/355
Job Number : 32063	
Estimate Number : 10208	
P.O. Number : <i>N/A</i>	Part Number : D350607043
This Issue : 4/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D350-607 REV F P7-9
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : 31989	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/16/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:E as Per DSI9318 06-01-24 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD350-607-043 CHG003

*KS 07/05/11* <sup>①</sup>

2.0	32063A	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D2989-041 B *32063A*
*ml 07/05/11*

3.0	32063B	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY

D2989-043 B *32063B*
*ml 07/05/11*

4.0	32063C	BASKET BASE ASSEMBLY (350)
-----	--------	----------------------------



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

D2221 B *32063C*
*ml 07/05/11*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

6.0	NAS1515H4	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 NAS1515H4 WASHER *M101428*
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2022101

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

5 D2022-101 Spacer B26664

8.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label B26312

9.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B30547

10.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B31106

11.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B28363

12.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B31107

*CP 5/15/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label

622553

14.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

521139

15.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

1101864

16.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

1104156

17.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

7 AN4-22A

Bolt

1100771

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

110240

*EP 4/25/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8

Washer

M103585

20.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416

Washer

M102929

21.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L

Washer

M103962

22.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M103641

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4

Washer

M103344

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3

Rivet

M101519

*EP 07/05/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104215

26.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

9 MS21042L4 Nut (or -4) M103914

27.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M102536

*Handwritten signature and date: 07/05/11*

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M103497

Exp Date: 10/2007

X 1

*Handwritten date: m107/05/11*

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten date: 107/05/11*

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

B 30992

32.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B 29806 ✓

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 \*D2324-1

Strut Ass'y

B 30139 ✓

34.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

B 30822 ✓

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

m103947 ✓

36.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

m104156 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: A Date: 01/05/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action / Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 32063

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

m102929 ✓

38.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

m103914 ✓

C 207105/11

①

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PU 7/5/11 ①

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-043

Location: \_\_\_\_\_

Neu C 7/5/11 ①

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207105/14

Job Completion



u 07-05-15

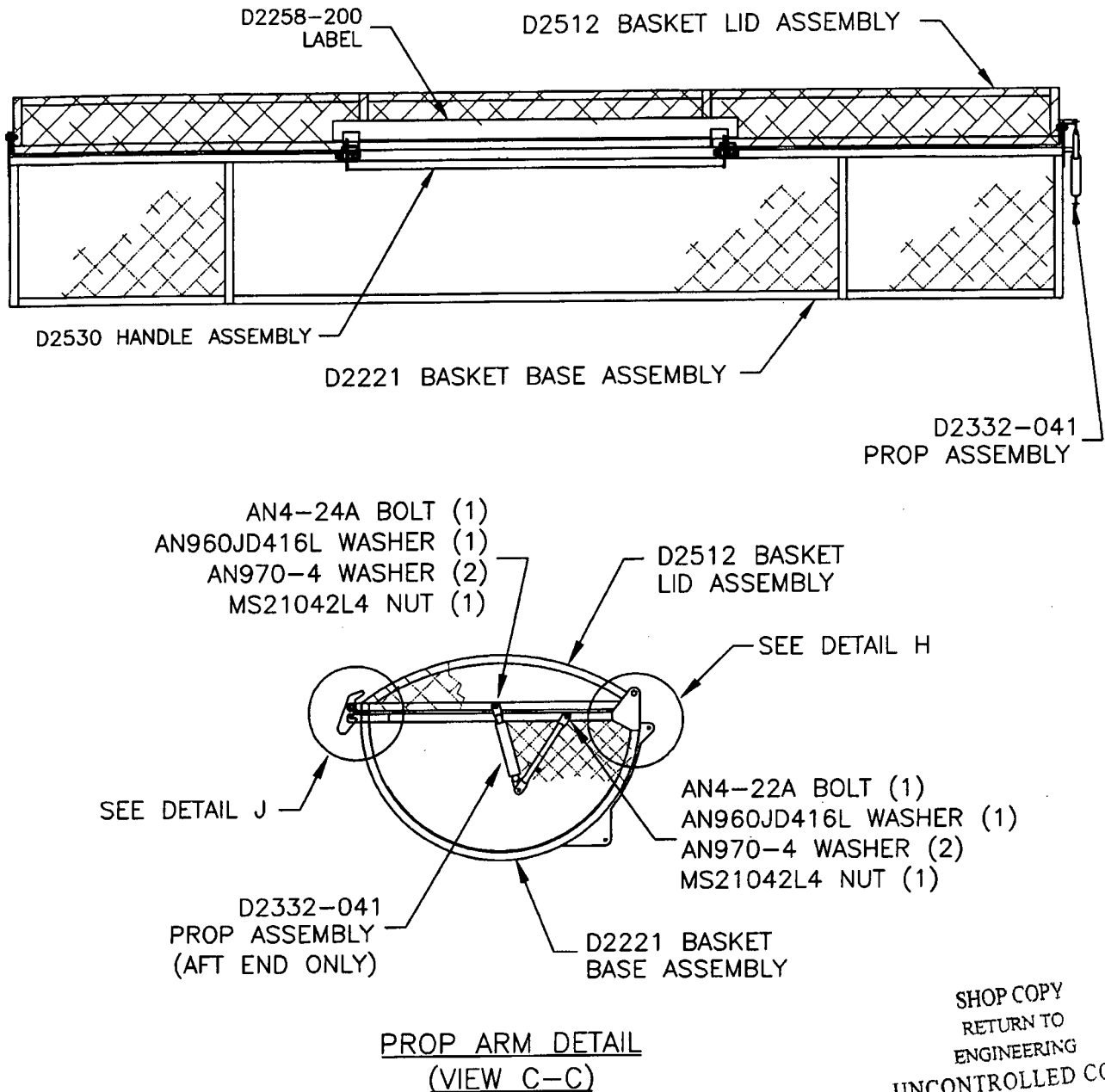
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

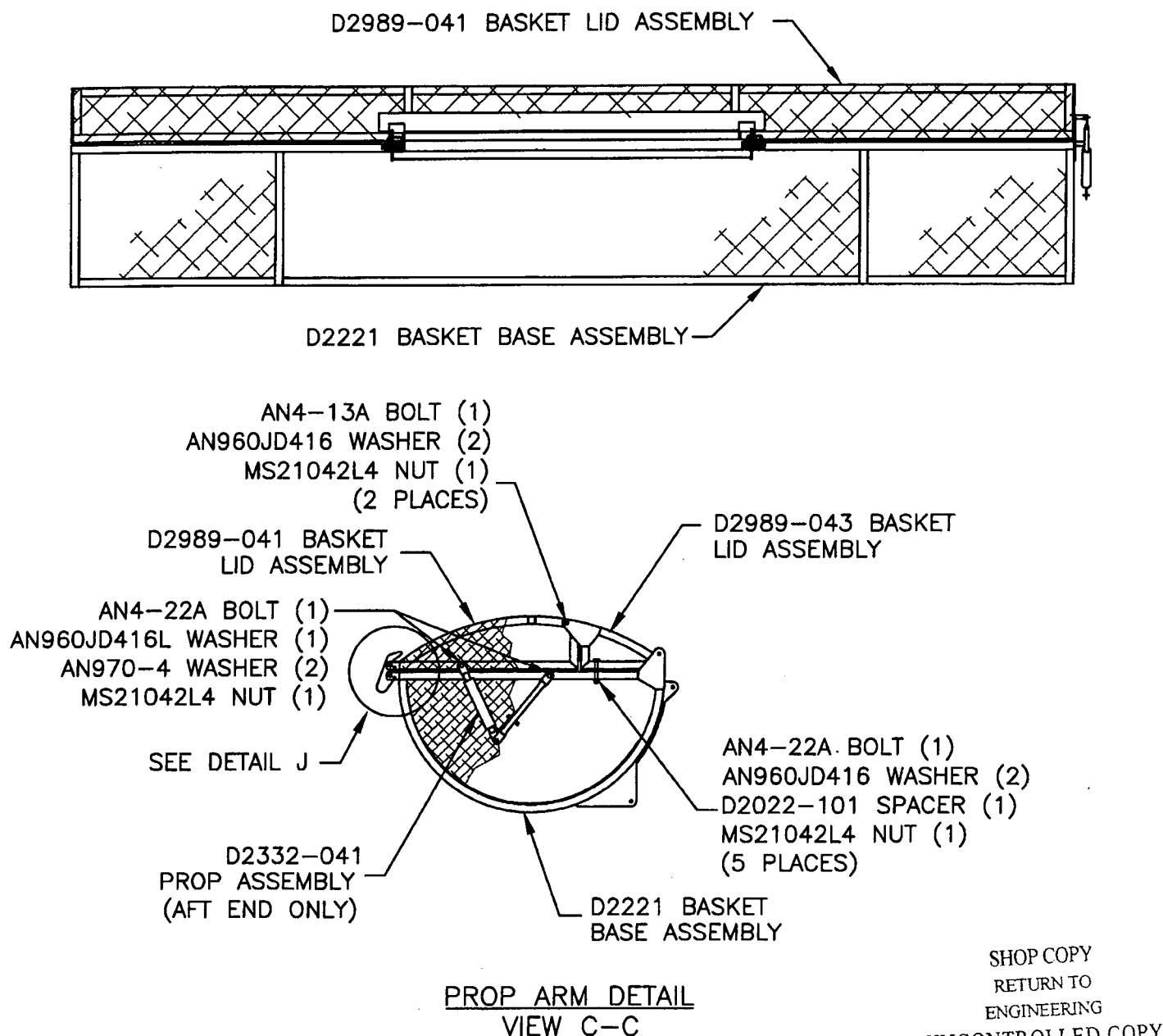


SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32063

**Figure 4 – Basket Replacement Parts**  
(D350-607-041 Heli-Utility-Basket™)

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Revision: **F**  
Date: 03.01.17



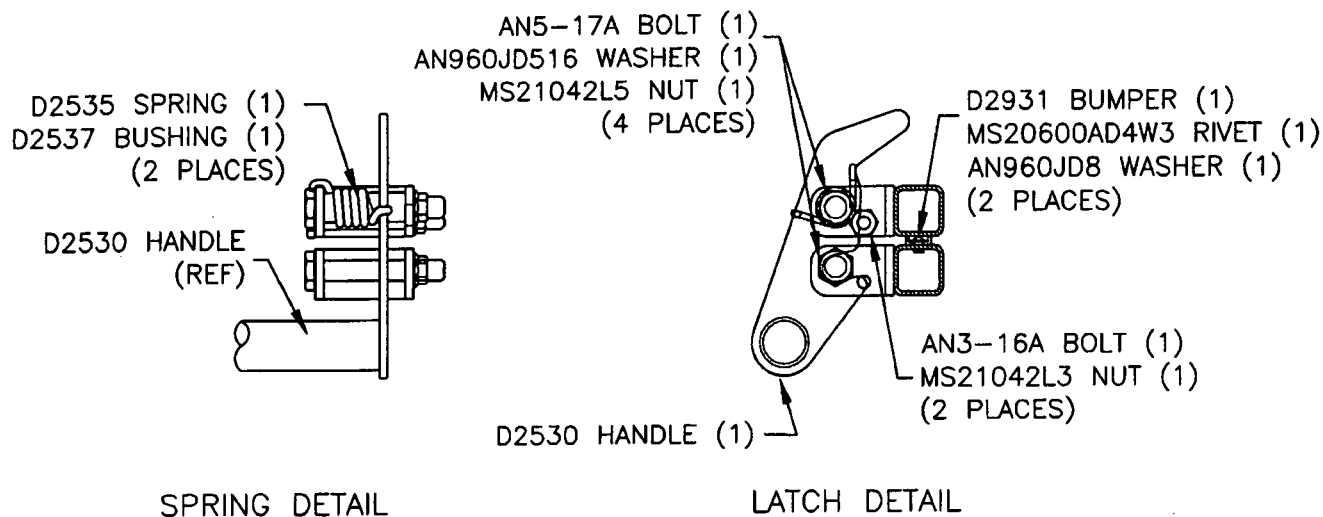
**Figure 5- Basket Replacement Parts**  
(D350-607-043 Heli-Utility-Basket™)

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
- WORK ORDER  
NO. 32063

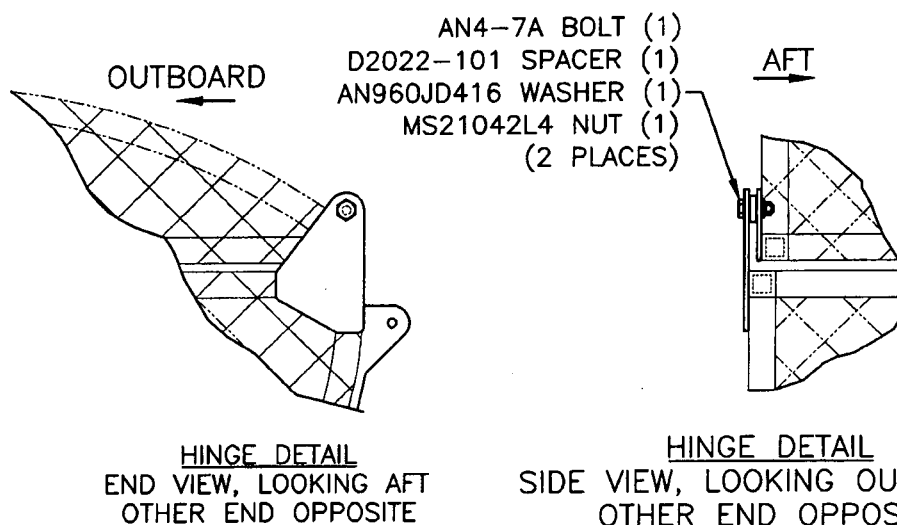
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Revision: **F**  
Date: 03.01.17





**DETAIL J:**  
HANDLE WELDMENT



**DETAIL H:**  
HINGE

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32063

**Figure 6 – Basket Replacement Parts**

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Revision: F  
Date: 03.01.17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

## DART SERVICE INSTRUCTION

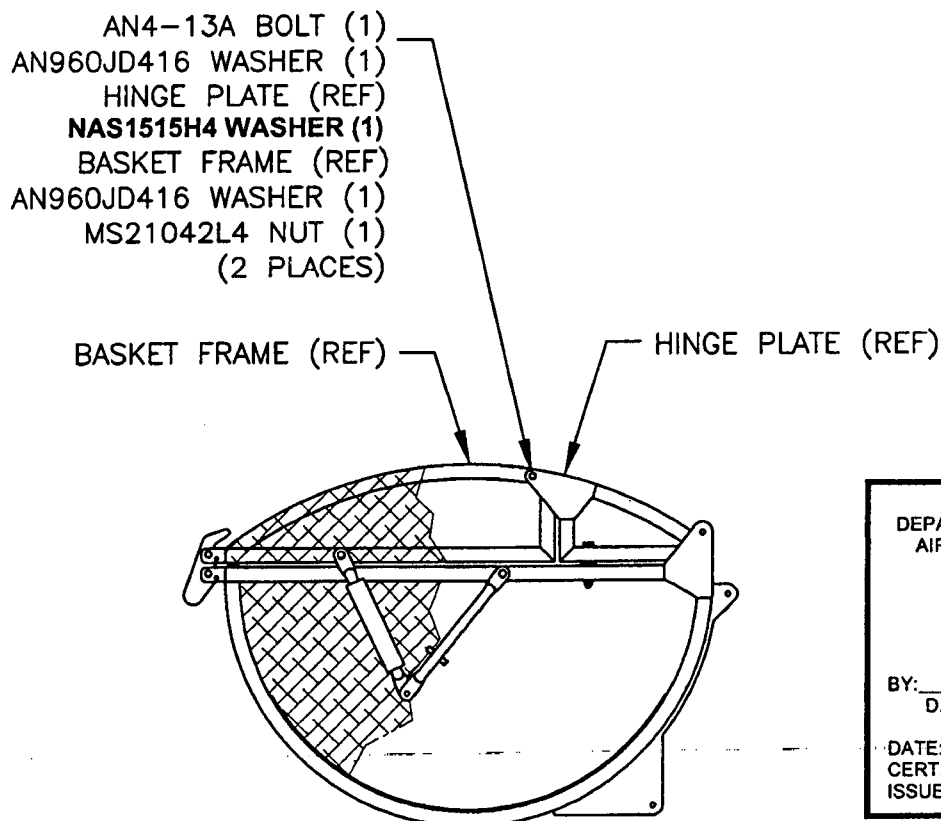
TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 32063

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE #02)

DATE: 06.01.06  
CERT. NO.: SH94-14  
ISSUE NO.: 4

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Date: Wednesday, 4/25/2007 2:38:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 32063A		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 4/25/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 31989A	Material	: N/A
	Type : LARGE FAB ASSY	Due Date	: 5/16/2007
Written By	: <u>                    </u>	Qty:	1 Um: Each
Checked & Approved By	: <u>                    </u>		
Comment	: Est Rev: Removed D2989-043 05-11-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31663	Basket Hoop
-----	--------	-------------



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: B31118

PCL 07.05.07

2.0	D2581	Mounting Bracket
-----	-------	------------------



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets B30552

PCL 07.05.07

3.0	D23273	Spacer Bushing
-----	--------	----------------



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing B28597

PCL 07.05.07

4.0	D2506	Placard
-----	-------	---------



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate B30548

PCL 07.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:14 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32063A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick: ✓

Qty Part number Description Batch  
15sf M304EX0.75-16F Expanded Metal

M103840

P/L 07-05-07

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M103706

P/L 07-05-07

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

P/L 07-05-07

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 07-05-09 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D 07-05-09 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M103706

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

07-05-10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/05/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32063A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black:

Wing Walk:

M 107153  
M 103707

M.L 07/05/10 (1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

m 07/05/11

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
07/05/11

Job Completion



07-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05.08.19 H

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

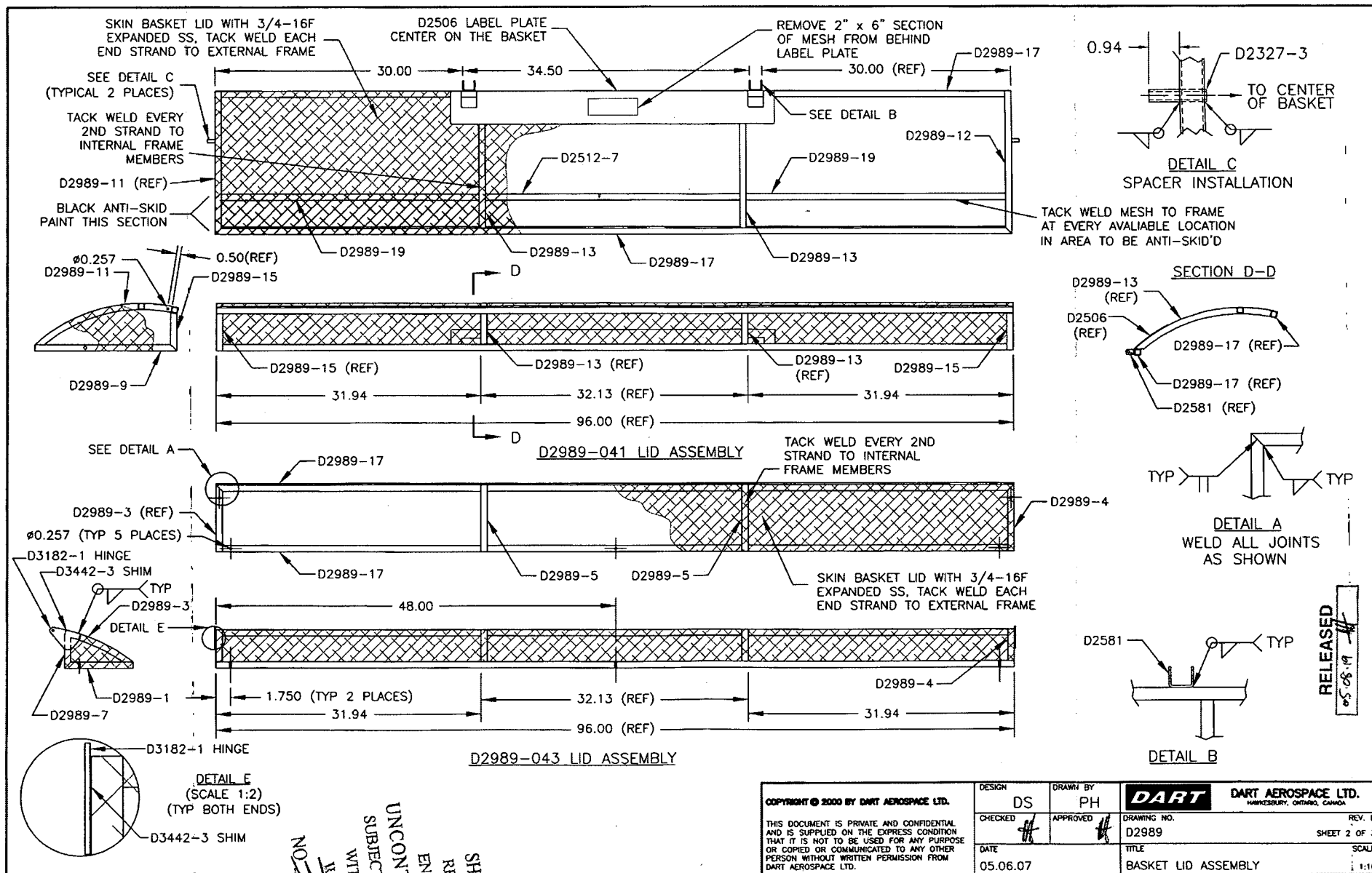
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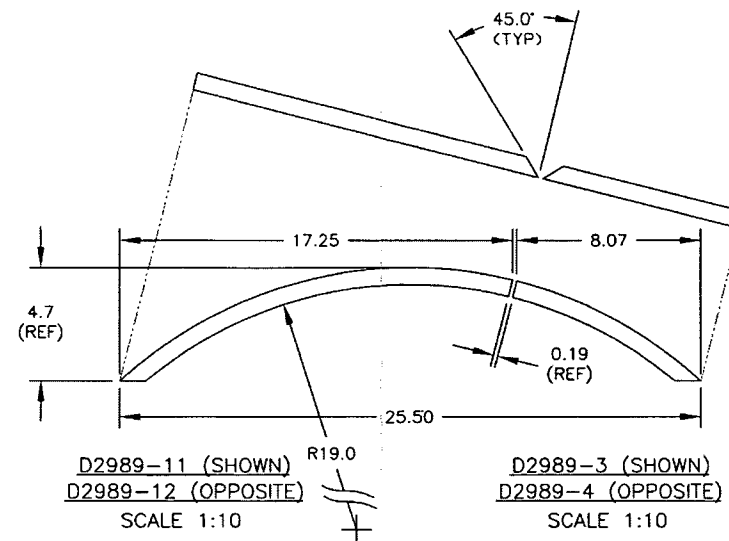
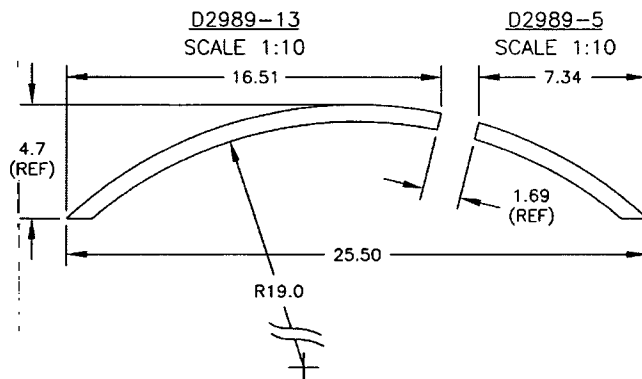
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2). PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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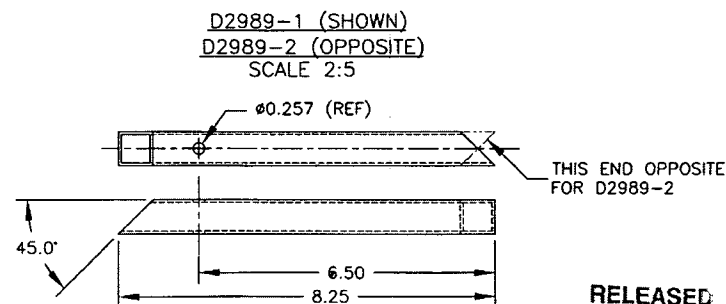
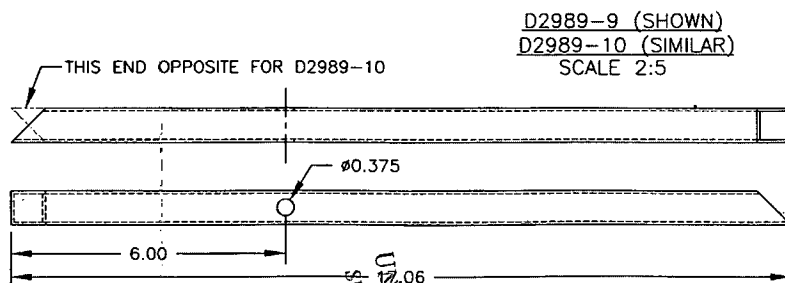
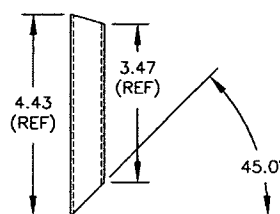
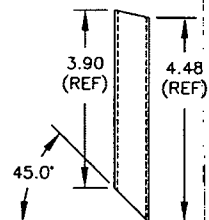
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WITHOUT NOTICE  
WORK ORDER  
NO 32063A





D2989-15  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



RELEASED  
05.08.19

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	

NO. 32063A  
WORK ORDER  
SUBJECT TO AMENDMENT  
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Date: Wednesday, 4/25/2007 2:38:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 32063B		
Estimate Number	: 10207		
P.O. Number	: N/A	Part Number	: D2989043
This Issue	: 4/25/2007 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 31989B	Material	: N/A
Written By	: <u>John. 04.25</u>	Due Date	: 5/16/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>John. 04.25</u>		
Comment	: Est Rev: I Removed D2989-041 05-11-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3182-1	Hinge	331342

Cpl 07.05.07

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3442-3	Shim	326740

Cpl 07.05.07

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number	Description	Batch
8sf M304EX0.75-16F Expanded Metal		M103840

Cpl 07.05.07

4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing.

Batch: M103907

Cpl 07.05.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: FE Date: 07/05/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32063B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PL 07-05-07

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

HD 07-05-09 ①

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

HD 07-05-09 ①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M103706

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

HD 07-05-10 ①

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

ML 07/05/11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

HD 07/05/11

Job Completion



U 07-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

496  
2x25.5  
1x30 5/8  
2x31.19



DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

**RELEASED**

05.08.19 H

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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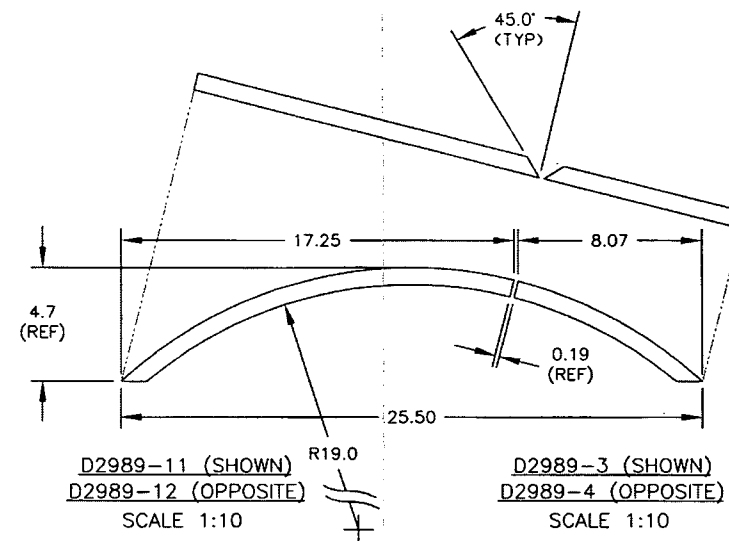
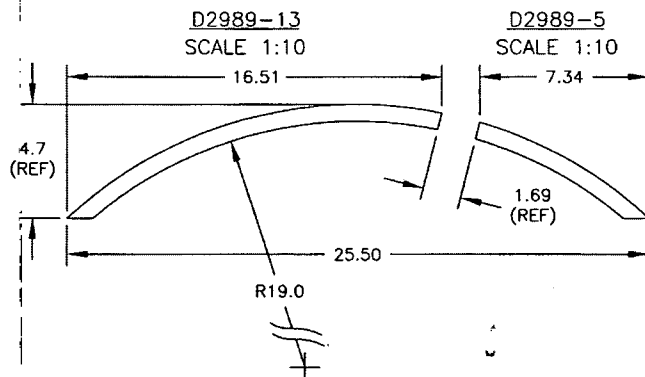
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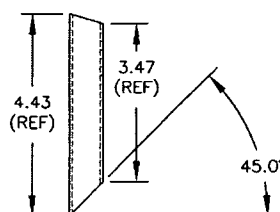
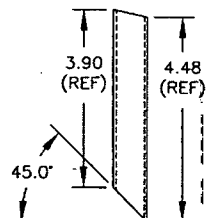
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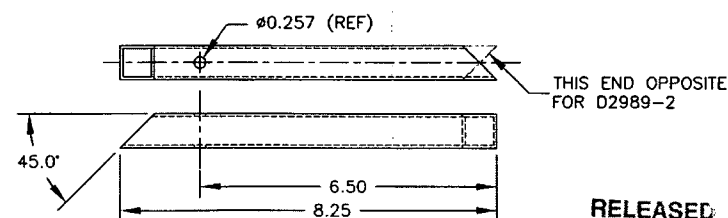




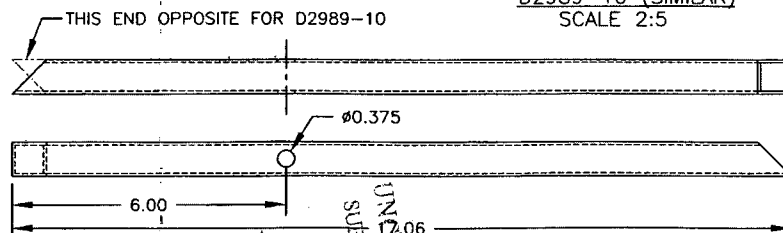
D2989-15  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)  
D2989-7  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-1 (SHOWN)  
D2989-2 (OPPOSITE)  
SCALE 2:5



D2989-9 (SHOWN)  
D2989-10 (SIMILAR)  
SCALE 2:5



RELEASED

05-08-19

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DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

NO. 20633B  
WORK ORDER  
SUBJECT TO AMENDMENT  
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Date: Wednesday, 4/25/2007 2:38:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 32063C		
Estimate Number	: 10189		
P.O. Number	: N/A	Part Number	: D2221
This Issue	: 4/25/2007 S.O. No. : N/A	Drawing Number	: D2221/D2235
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F/B1
Previous Run	: 31989C	Material	: N/A
Written By	: <u>H 07.04.25</u>	Due Date	: 5/16/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>H 07.04.25</u>		
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D3166-1	RIB	B31491 → 2*
---	---------	-----	-------------

Ppl 07.05.07

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2232-3	Hinge bracket	B30873
---	---------	---------------	--------

Ppl 07.05.07

3.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D2325	Support Gusset	B30546
---	-------	----------------	--------

Ppl 07.05.07

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2327-3	Bushing	B28597
---	---------	---------	--------

Ppl 07.05.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 32063C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B30552

*Ppl 07-05-07*

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B30564

*Ppl 07-05-07*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal M103840

*Ppl 07-05-07*

8.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M103987

*Ppl 07-05-07*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

*Ppl 07-05-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/25/2007 2:38:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 32063C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-05-09 ①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 07-05-09 ①

12.0

POWDER COATING

POWDER COATING



11163706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PD 07-05-09 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 07-05-11 ①

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 07-05-14

Job Completion



u 07-05-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 07/05/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-10	9.0	Upon Powder Coating, A weld WAS notice missing on the bottom of the basket BASE. The material was Jacked at the bottom, and welded the rest of the way around.  R-C: Human error.	[Signature] QSI042	Finish welding affected Area.	PD 07-05-10	[Signature] 07/05/10	[Signature] QSI042	[Signature] 07-05-10
	QCA to inspect weld			MA 07-05-10				
	Re-powder coat the Base as per WRO.			MA 07-05-10				

NOTE: Date & initial all entries

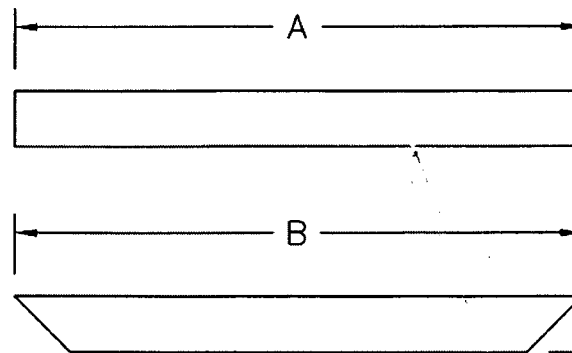


**DART**

DESIGN BW	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

**RELEASED**05.08.19 *[Signature]*PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\phi 0.257$  HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH  
D2989-041/-043 BASKET LID

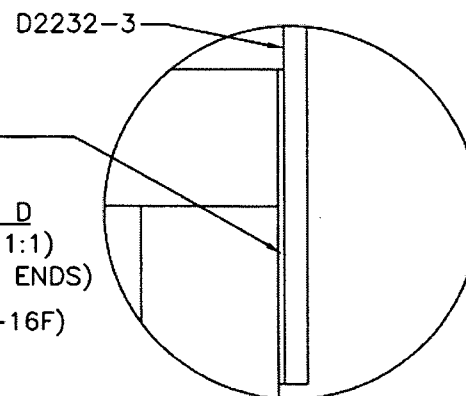
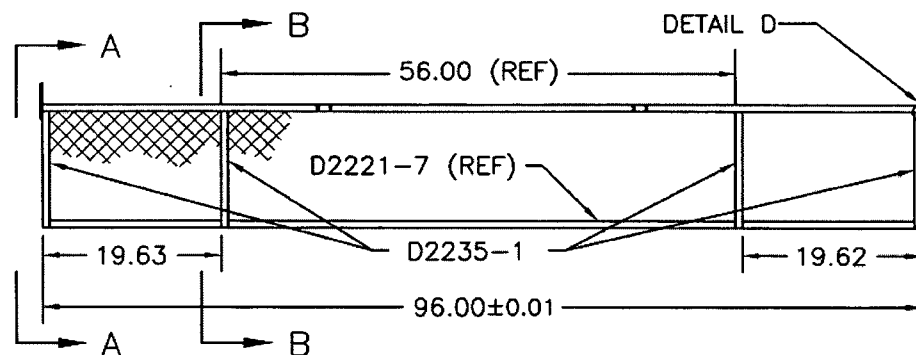
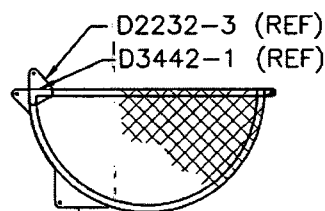
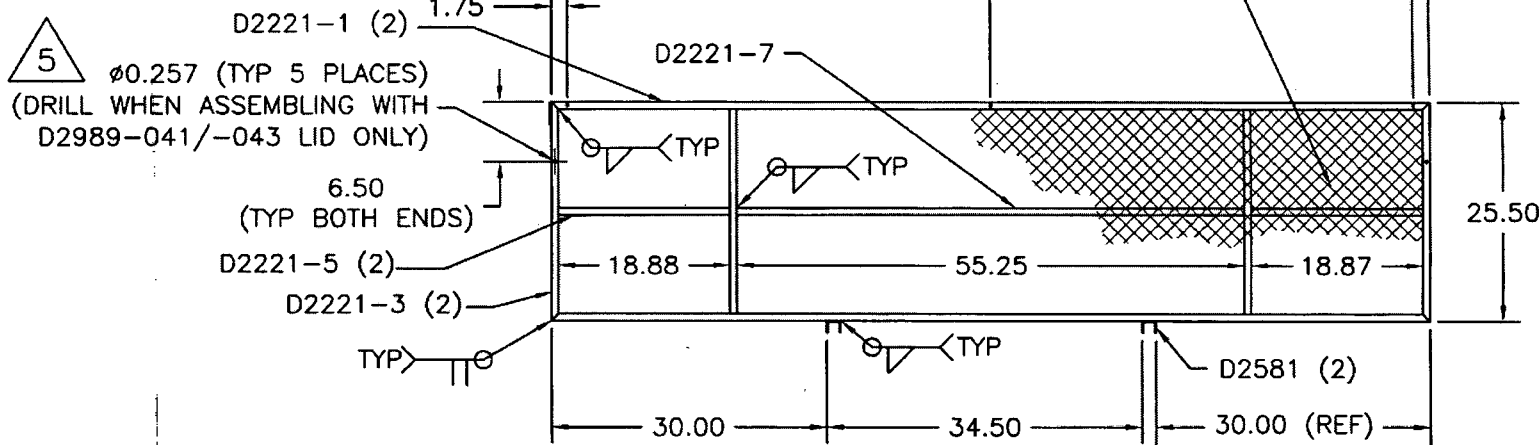
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.07	TITLE	D2221	REV. F
				SHEET 2 OF 3
				SCALE
				1:20

SKIN INSIDE SURFACE OF  
BASKET WITH MESH. TACK  
WELD EACH END OF STRAND  
TO FRAME



DETAIL D  
(SCALE 1:1)  
(TYP BOTH ENDS)

RELEASED

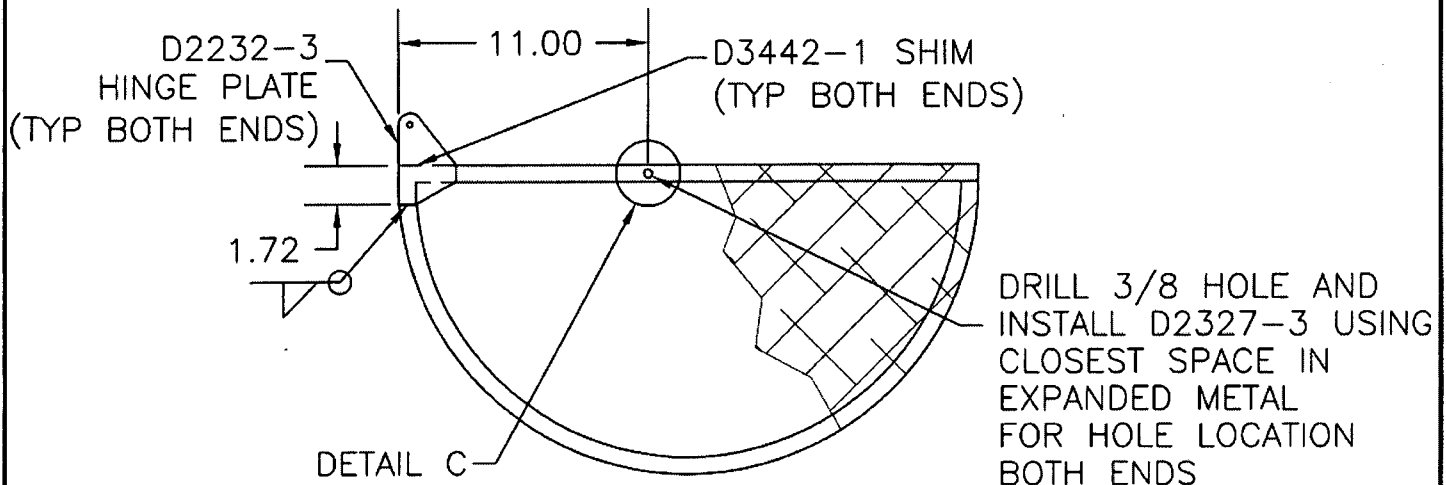
05.08.19

# D2221 BASKET BASE ASSEMBLY

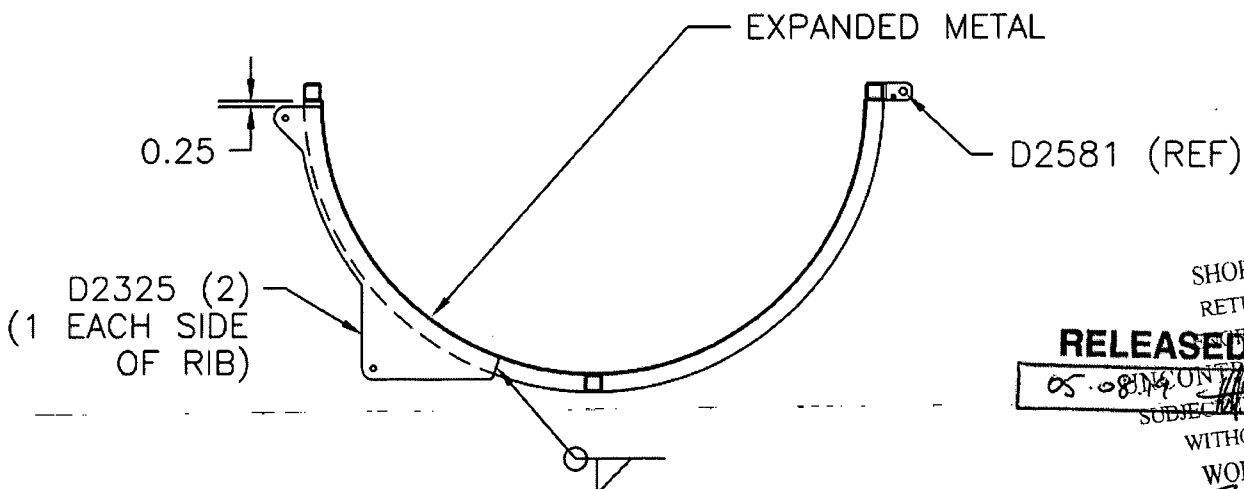
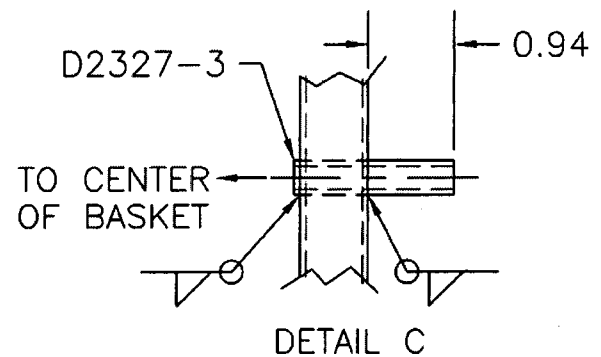
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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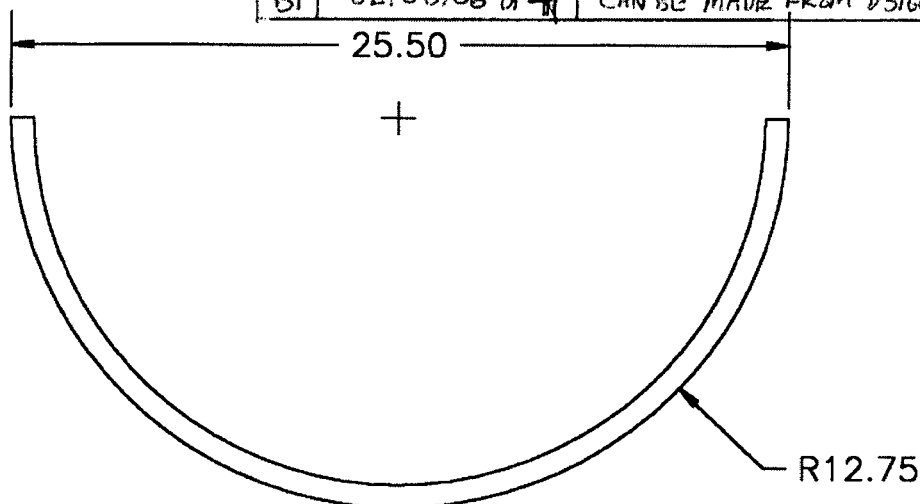
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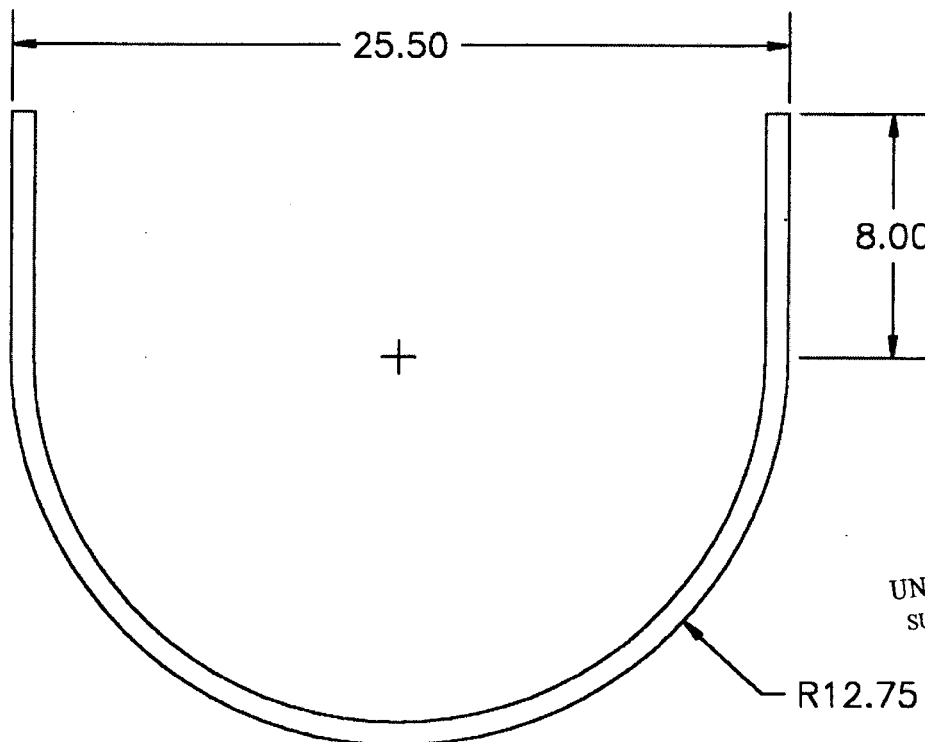
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B-WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		

BI 02.08.06 *UPH* CAN BE MADE FROM D3166-1

RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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